

Work Order ID 63888

Thursday, November 18, 2010 10:11:39 AM



Page 1

Item ID: D4271-013
Revision ID: PRELIM
Item Name: Aft Beam Assembly

Accept



Setup Start



Stop

PRELIMINARY ISSUE

Start Date: 11/18/2010 Start Qty: 2.00
Required Date: 11/22/2010 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MUF Date: 10-11-18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	PA1								

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

B 10-11-19 ①

110

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PA1



QC

Memo

0.00

Quality Control

Don't only
S10/11/22 @

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging



test


Work Order ID 63888

Thursday, November 18, 2010 10:11:39 AM

Page 2

Item ID: D4271-013 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Aft Beam Assembly
Start Date: 11/18/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 11/22/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

TEST RECALL *Rev. A 10.12.02*
10.11.23

POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

MF
10-11-30

Picklist Print

Page 1

Thursday, November 18, 2010 10:11:39 AM

Work Order ID: 63888

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly





Start Date: 11/18/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
\ D4148-3  Stud Receiver, Lower		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			2						
				63449			2						
\ D4148-5  Eyebolt Stud B 61005		Manufactured	No			100	Each	7.0000	1	2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			7						
				61005			3						
				63450			4						
\ D4274-3  Plate, Aft Support B 63885		Manufactured	No			100	Each	0.0000	2	4			
\ D4276-1  Aft Beam AN3C12A B 63882		Manufactured	No			100	Each	0.0000	1	2			
		Purchased	No			100	Each	61.0000	8	16			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			61						
				112314			8						
				114761			11						
				116022			42						

Picklist Print

Thursday, November 18, 2010 10:11:39 AM

Work Order ID: 63888

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 11/18/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18 Purchased

No

100

Each

391.0000

8

16



Rivet



10-11-19

8

Location

Loc Qty

Loc Code

ST323

391

114808

152

115037

239

MS21043-3

Purchased

No

100

Each

2,226.000

8

16



Nut



10-11-19

8

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2150

112314

2150

NAS1149C0332R

Purchased

No

100

Each

4,239.000

16

32



Washer



10-11-19

16

Location

Loc Qty

Loc Code

ST297

4239

113524

10

113737

150

115000

125

115698

35

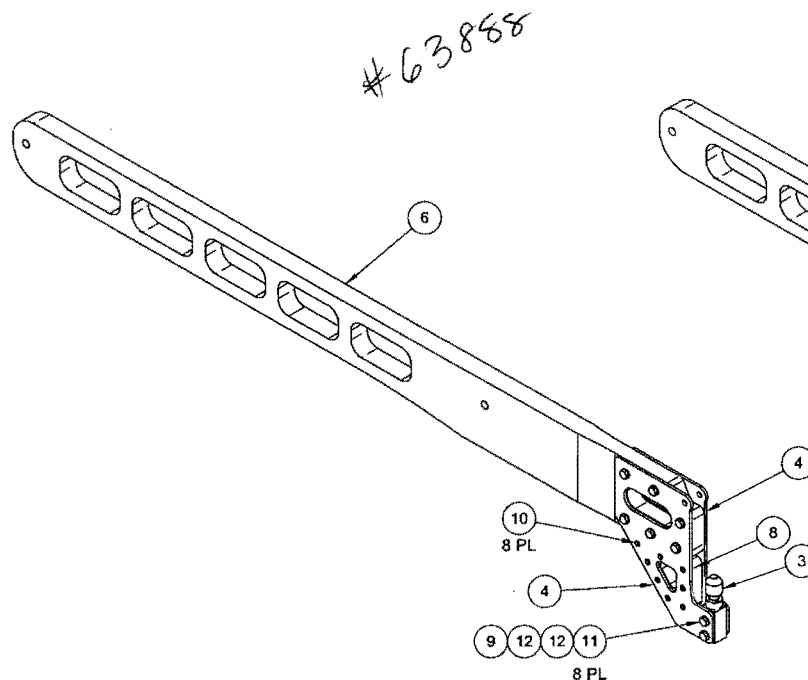
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1919

116025

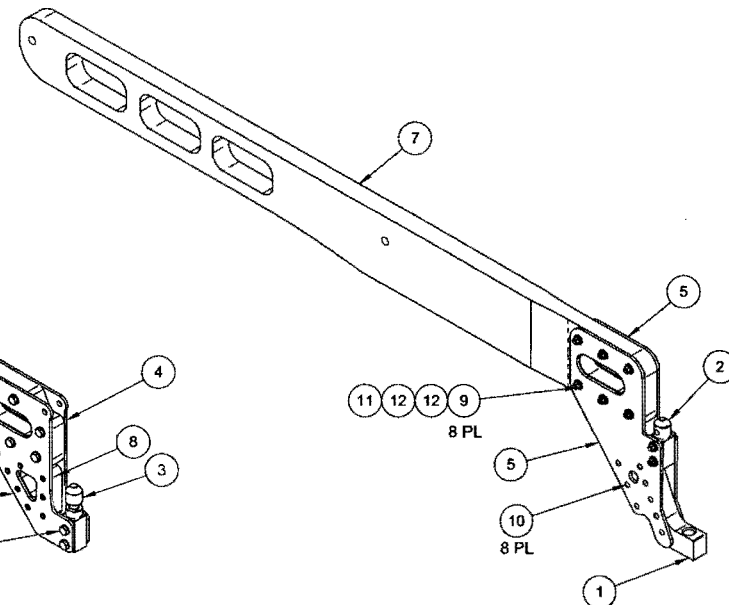
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ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	8	8	AN3C12A	BOLT
10	8	8	MS20615-4M18	RIVET
11	8	8	MS21043-3	NUT
12	16	16	NAS1149C0332R	WASHER



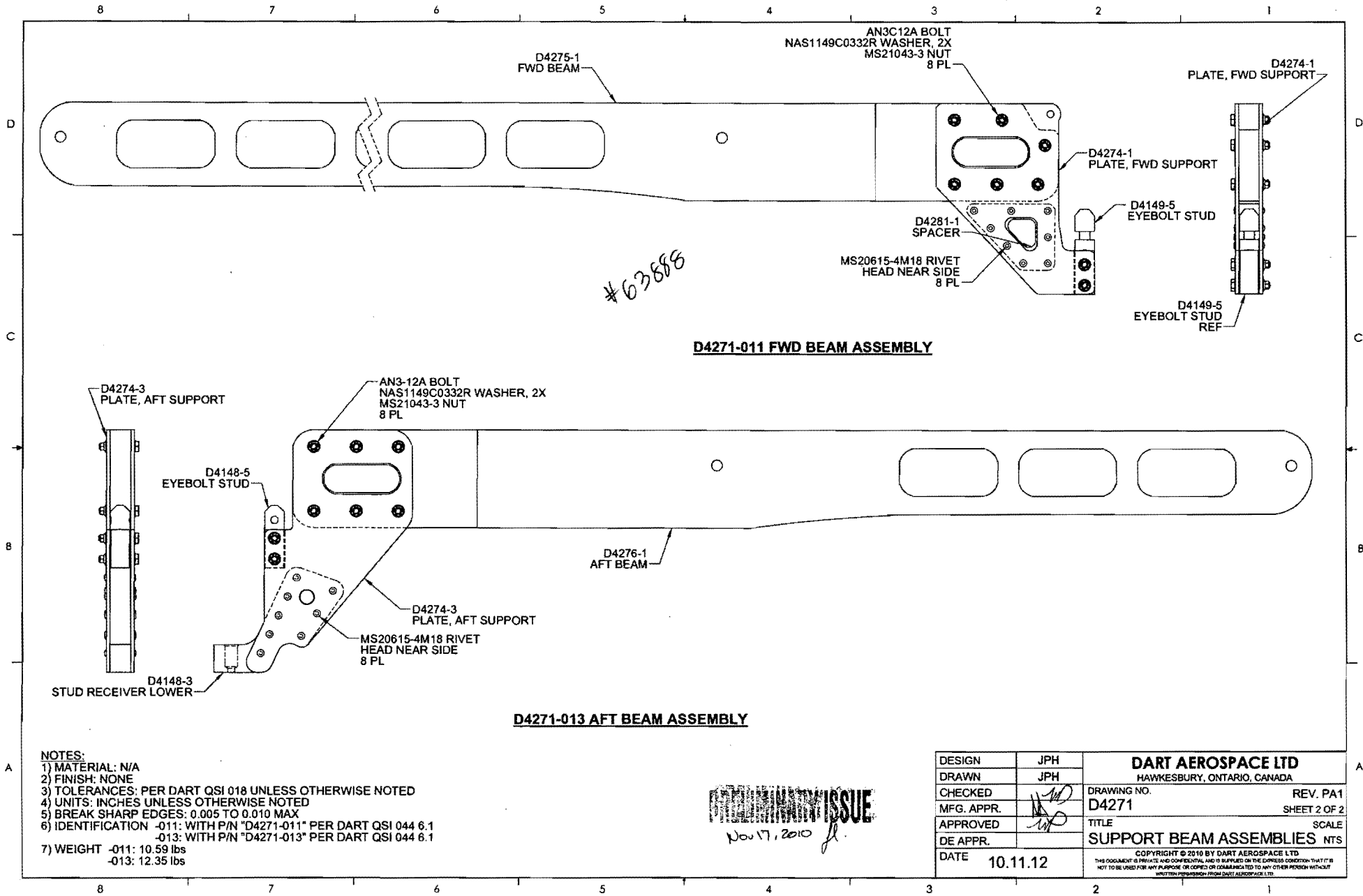
D4271-011 FWD BEAM ASSEMBLY

PRELIMINARY ISSUE
Nov 17, 2010 fl.



D4271-013 AFT BEAM ASSEMBLY

PA1	PRELIMINARY	JPH	10.11.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4271	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



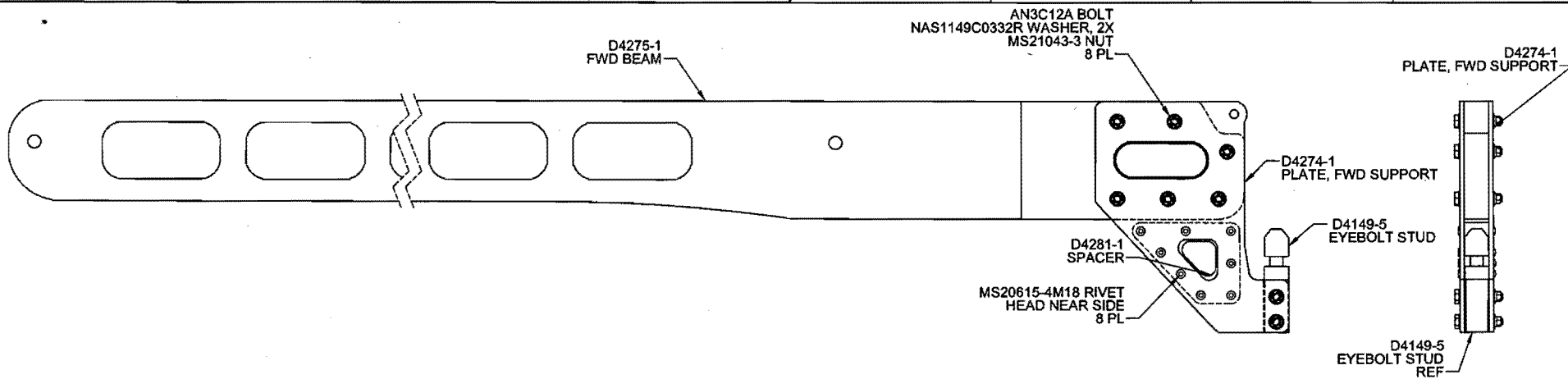
D4271-011 FWD BEAM ASSEMBLY

D4271-013 AFT BEAM ASSEMBLY

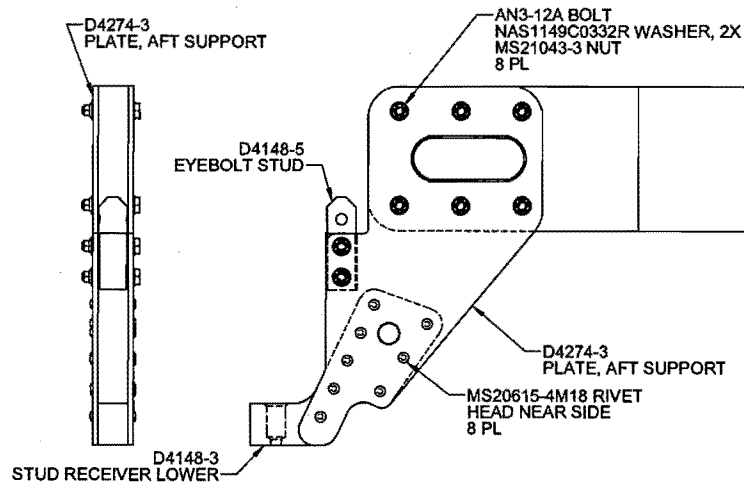
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -011: WITH P/N "D4271-011" PER DART QSI 044 6.1
 -013: WITH P/N "D4271-013" PER DART QSI 044 6.1
 - 7) WEIGHT -011: 10.59 lbs
 -013: 12.35 lbs

OUT OF DATE ISSUE
 Nov 17, 2010

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4271	REV. PA1
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	
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D4271-011 FWD BEAM ASSEMBLY



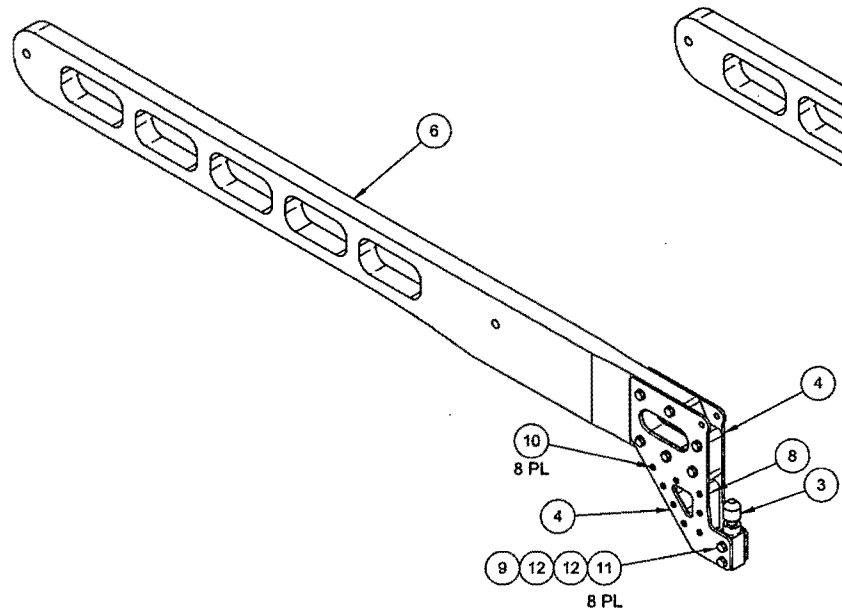
D4271-013 AFT BEAM ASSEMBLY

NOTES:

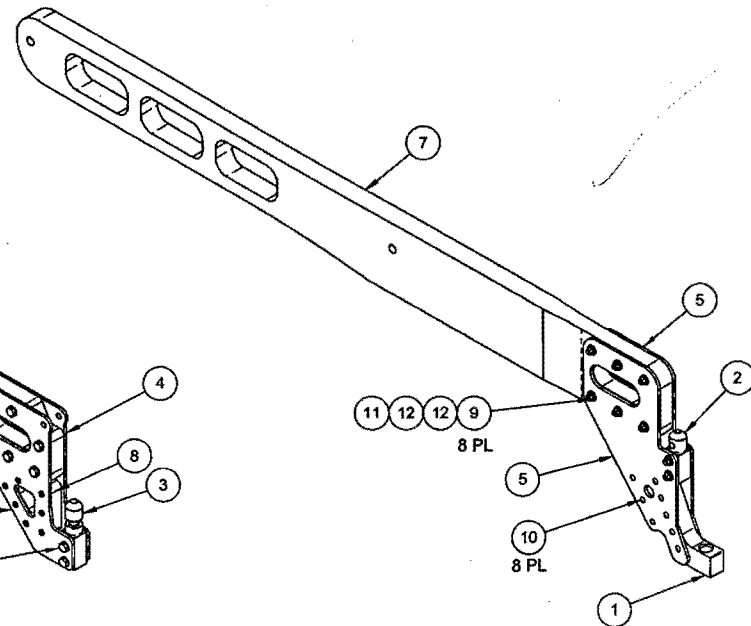
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
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D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4271	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES NTS	
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